

303 / "

Work Order ID 108838

108838

Page 1

October-29-13 10:09:10 AM

Item ID: D2972

Accept

Revision ID:

Item Name: Bushing

Start Date: 10/29/13 **Start Qty:** 40.00

40

Required Date: 10/29/13 Req'd Qty: 40.00

40

Reference:

Approvals:

Process Plan: M15

Date: 13-10-30

Date: **SPC (Y/N)**

Date:

Date:

Run Start

Stop

NR1

NR2

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		
			<input type="checkbox"/> Other	

Work Order ID 108838

October-29-13 10:09:10 AM

108838

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Item ID: D2972

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 10/29/13 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	identify: <u>STC22</u> Memo	0.00				40X	DAS 28 9-89	13-11-1	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							<i>10/29/13-11-06</i>

PLB 11-04

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
Suspected Unapproved <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												
FAULT CATEGORY												
Landing Gear			General									
			Bending <input type="checkbox"/>		Bend <input type="checkbox"/>		Folio/Program <input type="checkbox"/>		Outside Dimensions <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>	
			Centre Not Concentric <input type="checkbox"/>		BOM/Route <input type="checkbox"/>		Grain <input type="checkbox"/>		Over/Under tolerance <input type="checkbox"/>		Set-up <input type="checkbox"/>	
			Cracks <input type="checkbox"/>		Broken/Damage/Defect <input type="checkbox"/>		Hardware <input type="checkbox"/>		Part Incorrect <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>	
			Crimp/Kink/Ripple/Wave <input type="checkbox"/>		Burr <input type="checkbox"/>		Inspection Incomplete/Unqualified <input type="checkbox"/>		Part Lost/Missing <input type="checkbox"/>		Weld <input type="checkbox"/>	
			Cuffs <input type="checkbox"/>		Contamination <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>		Part Moved <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>	
			Crushing <input type="checkbox"/>		Countersink <input type="checkbox"/>		Misaligned/off center <input type="checkbox"/>					
			Heat Treat <input type="checkbox"/>		Cut Too Short <input type="checkbox"/>		Mislabeled <input type="checkbox"/>					
			Inspection Strip in Tube <input type="checkbox"/>		Drawing <input type="checkbox"/>		Misread <input type="checkbox"/>					
			Marks/Chatter <input type="checkbox"/>		Drill Holes <input type="checkbox"/>		Off-set <input type="checkbox"/>					
			Turning Sequence <input type="checkbox"/>		Finish <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>					
			Wave/Twist in Tube <input type="checkbox"/>		Fit/Function <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>					

Picklist Print

October-29-13 10:09:10 AM

Page 1

Work Order ID: 108838

Parent Item: D2972

Parent Item Name: Bushing

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A00.05.18New IssueEC
IPP Rev:B Now Made In-House 07-07-19 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000 303 Round Bar 1.00		Purchased	No				f	95.3180		4			

Location	Loc Qty	Loc Code
MAT028	95.31801579	
121070	1.5789E-05	
✗ m126618	95.318	

4.83' FK 13/11/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Fault Category	Action
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>	Other <input type="checkbox"/>
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>	
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	

DART AEROSPACE LTD	Work Order:	108838
Description: Bushing	Part Number:	D2972
Inspection Dwg: D2972	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

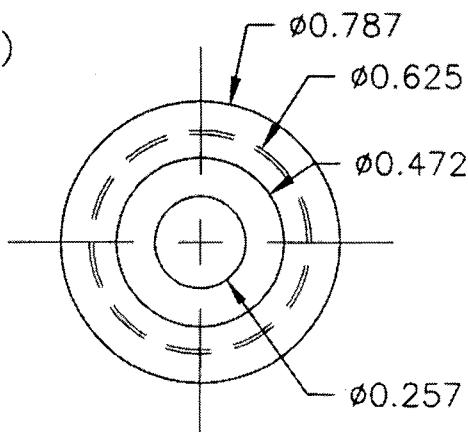
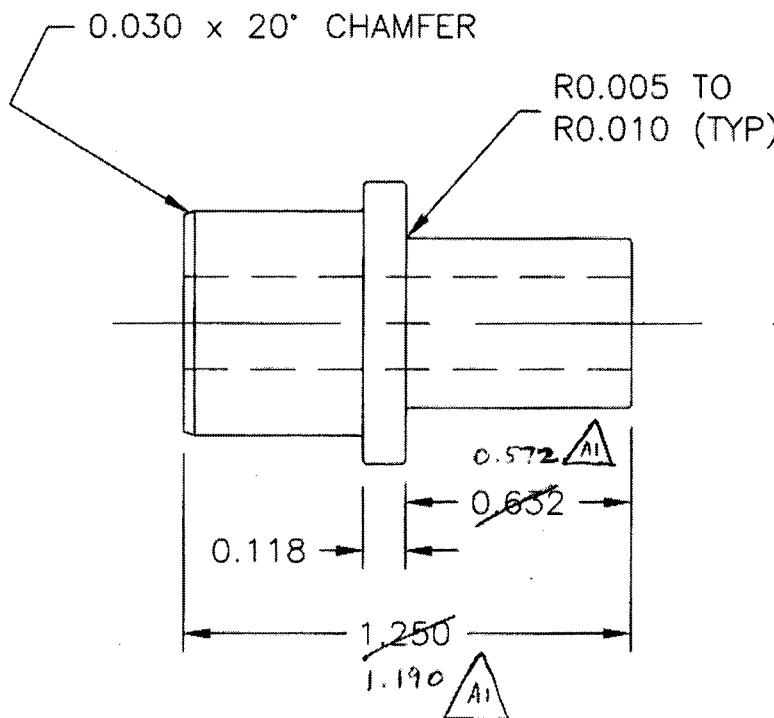
SAS

Measured by:	44 9-89	Audited by:	1	Prototype Approval:	N/A
Date:	13/10/31	Date:	B-1H	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2972	REV. A SHEET 1 OF 1
DATE 00.03.13		TITLE BUSHING	SCALE 2:1
A	00.03.13	NEW ISSUE	

RELEASED
00.05.11 #1088838
13-10-30
MCU

MATERIAL: AISI 303 STAINLESS STEEL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
RADIUS ALL INSIDE EDGES 0.005 TO 0.010
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
ALL DIMENSIONS ARE IN INCHES

A1 01.03.12 REDUCE LENGTH OF BUSHING #4P

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